

Work Order ID 61975

Monday, September 13, 2010 2:30:36 PM



Page 1

Item ID: D2282-5

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 9/13/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-9-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg D2282 and Folio FA189
2-Deburr

SL 11/3/1

ENSURE TO USE 304 SS ONLY

303 SS IS NOT ACCEPTABLE

40 *[Signature]*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/3/1

40 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2282-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 9/13/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

SM 11/03/01



QC

Memo

0.00

Quality Control

40

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11-3-2

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03

MF

11-03-03

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Picklist Print

Monday, September 13, 2010 2:30:56 PM

Page 1

Work Order ID: 61975



Parent Item: D2282-5



Parent Item Name: Tube

Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPR Rev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

29.0947

0.18006

7.581474



304 SS Roundbar .750

SA 11/3/11

Location

MAT028

Loc Qty

29.09473684

Loc Code

~~113216~~

17.8447368

~~113457~~

11.25

M116501

4.8 PL

W/O:		WORK ORDER CHANGES					
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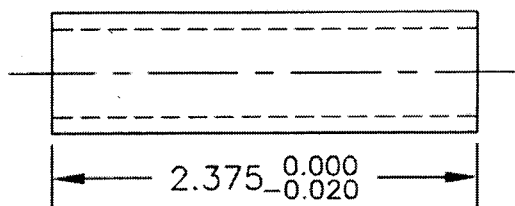
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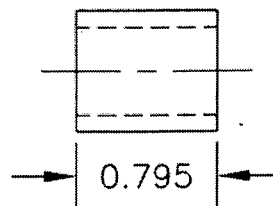
1st 3-6-75
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT
 UNCONT
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 R
 SI
 DART
 92B

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

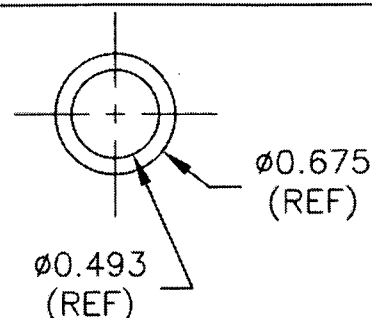
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[Signature]
 05/09/16



D2282-3

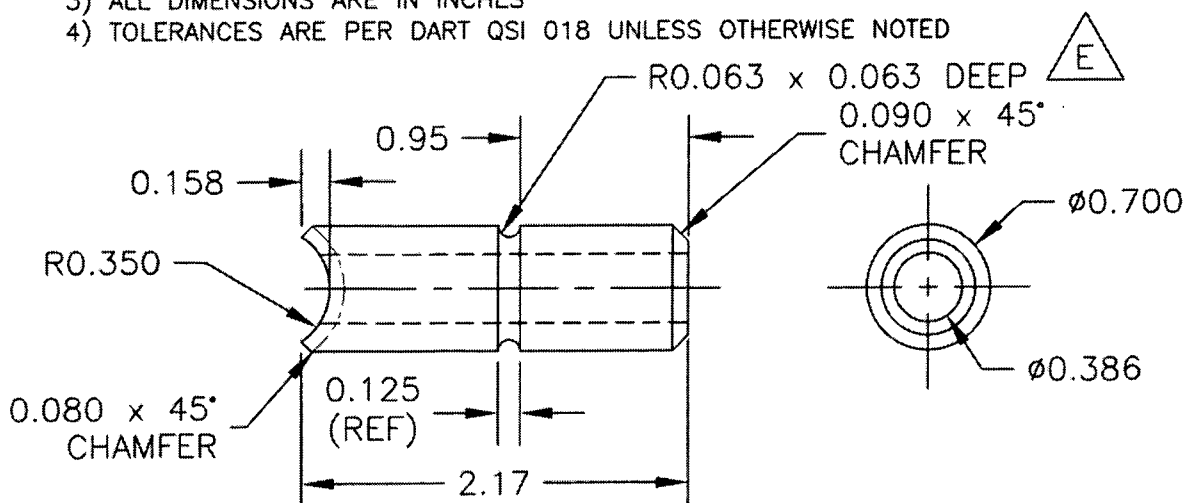


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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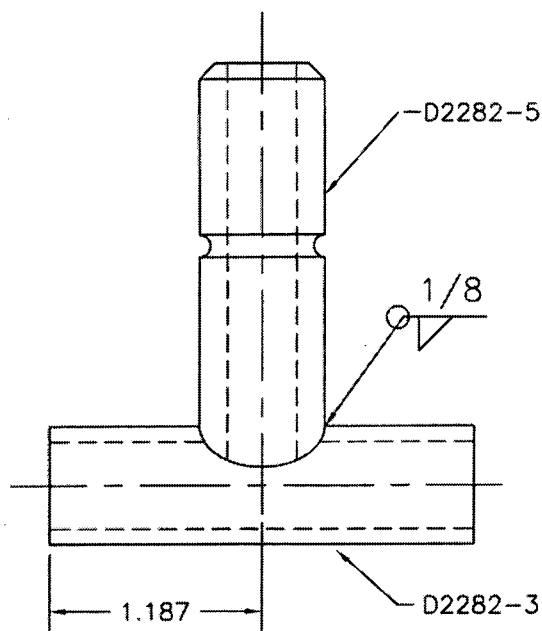
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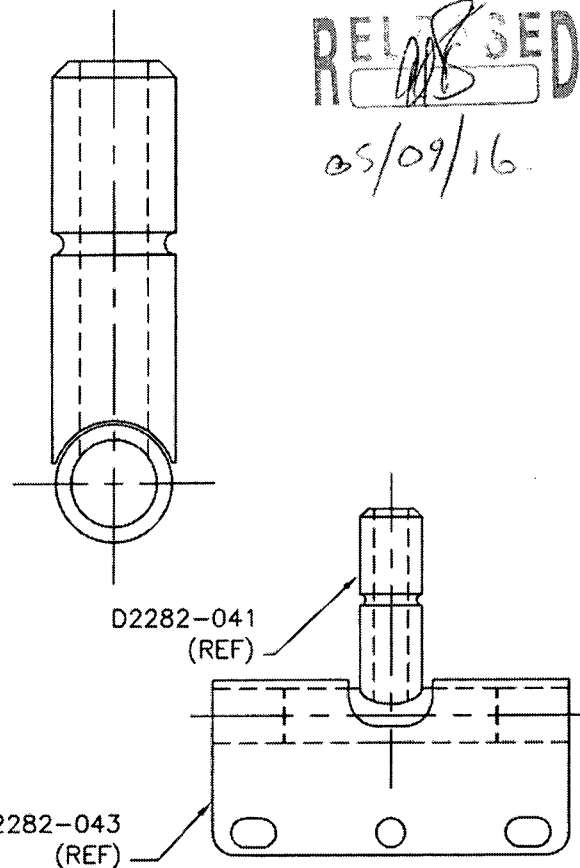
NOTE: Date & initial all entries



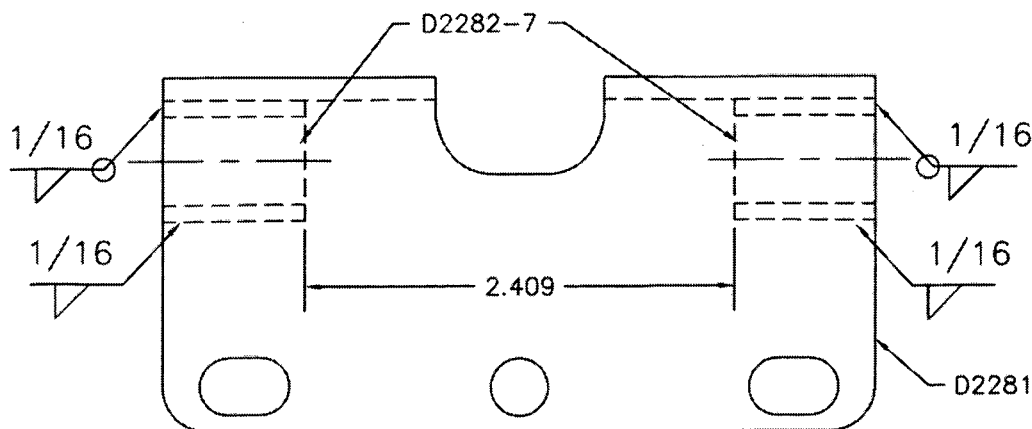
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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